

Date: Friday, 2/23/2007 8:31:58 AM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
 Job Number : 30890 -1
 Estimate Number : 10351
 P.O. Number : N/A Part Number : D30413
 This Issue : 2/23/2007 S.O. No. : N/A Drawing Number : D3041 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : UNDER REVIEW C
 Previous Run : 24407 Material : N/A
 Due Date : 3/10/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : J 07.02.23
 Comment : Est:A 01.07.11 New Issue SM/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



4.923



Comment: Qty.: 0.1094 f(s)/Unit Total : 2.1882 f(s)
 Lug Extrusion
 (D2423) Batch: B30062

En 07/03/12

x45

2.0 BAND SAW BAND SAW



32mm



Comment: BAND SAW
 Cut D2423 Extrusion: 1.250" Long

En 07/03/12

x45

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Issue 1.0 3287

02/07/03



45

Comment: HAAS CNC VERTICAL MACHINING #1
 Check for cracks while loading into the machine
 Machine as per Folio FA153 and Dwg D3041
 Tumble and Deburr rough edges after tumbling
 Identify as D3041-3

machine per drawing D3041 Rev C

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Receive + Inspect for



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

transit damage 07/04/02 (45)

5.0 QC5 SECOND CHECK


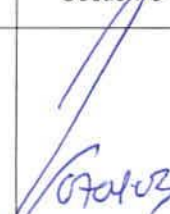




Comment: SECOND CHECK

Inspect Level 5 07/03/03 43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070403	3.0	2 parts scrap due to incorrect cutting @ Dart.	 05/04/02	43 parts remains	N/A	 070403	 05/04/02	 070403

NOTE: Date & initial all entries

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Drawing Name: CLAMP

Job Number: 30890

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



43x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/04/09

7.0

POWDER COATING

POWDER COATING



M103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

FL

07/04/10 (43)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



43x

Comment: INSPECT POWDER COAT

M-L

07/04/10

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch
1 D2611 Bearing

Batch

B31190 39

X 1 more

SB 07/05/02 39

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTU

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

SB 07/05/02 (39)

11.0

QC5

INSPECT WORK TO CURRENT STEP



70502

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 07/05/03 (39)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070503	10.0	Please add a step to touch-up stake marks with white Imron. Perm. Change		07-05-03		070503	070503

Part No: D3641-3 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: 1 Date: 07/05/04
QA: N/C Closed: _____ Date: _____

NCR: <u>36890</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-12	7.0 8.0	hole Ø.8115 was not masked off, prior to Powder coating on all parts.	QS1042	Sand lightly on the inside of the hole ONLY to remove powder coat. Touch up with Alodine as per QS1005. *Sand using a 320/400 grit.*	M.P. 07/04/26	SB 07/05/02	QS1042	07-04-12
07-04-12	10.0	Due too the powder coat being in the Ø.8115, when the bearing was press fitted in, the Aluminum was stressed, and pushed out the opposite side around the hole.	QS1042	3 parts scrapped & destroyed. keep the 2 bearings for assembly	SB 07/05/02	070502	QS1042	07-04-12

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAIMP

Job Number: 30890

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/27/05/04

Job Completion



h 07-0503

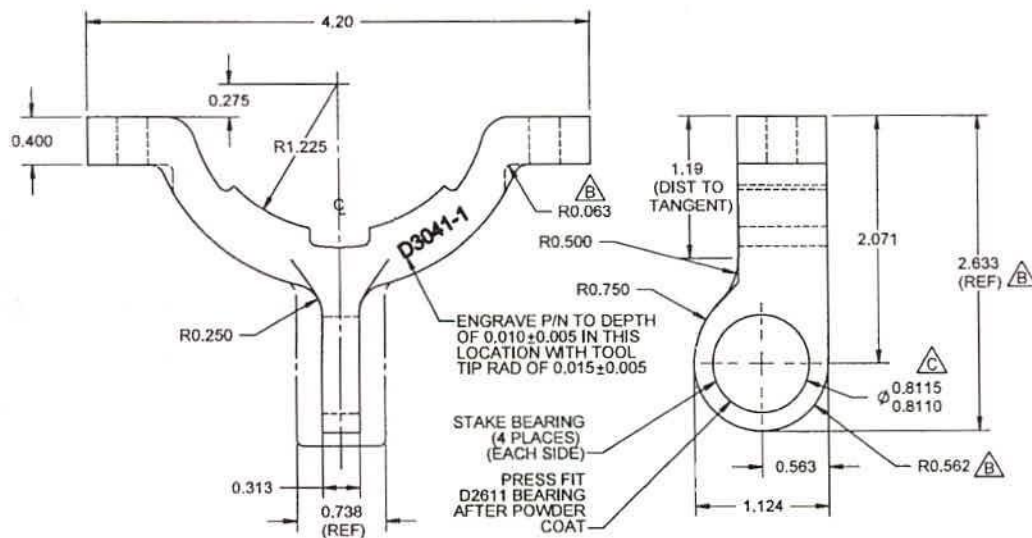
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

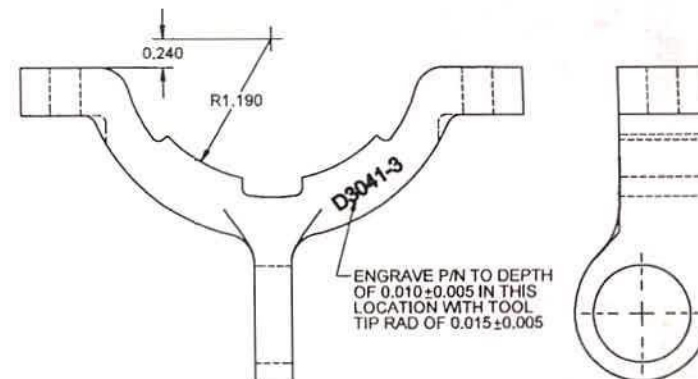
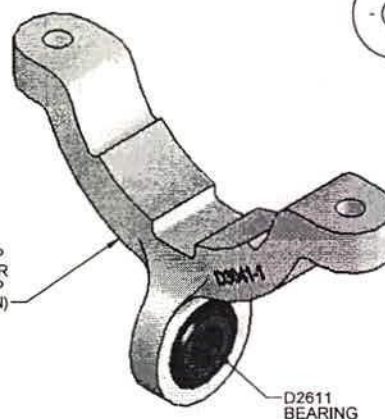
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3041-1 CLAMP

D3041-1 CLAMP
(SHOWN) OR
D3041-3 CLAMP
(NOT SHOWN)



D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)

RELEASED

06.11.17

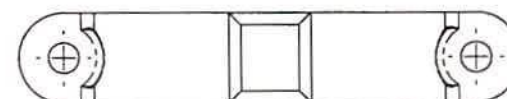
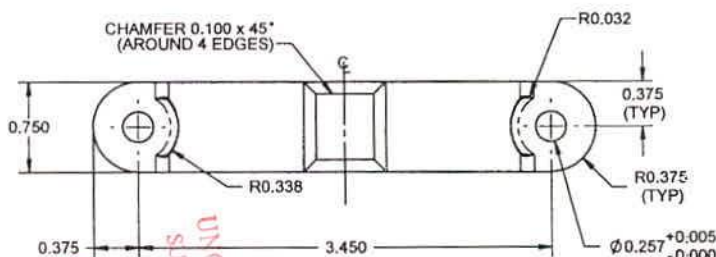
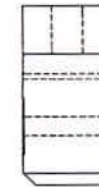
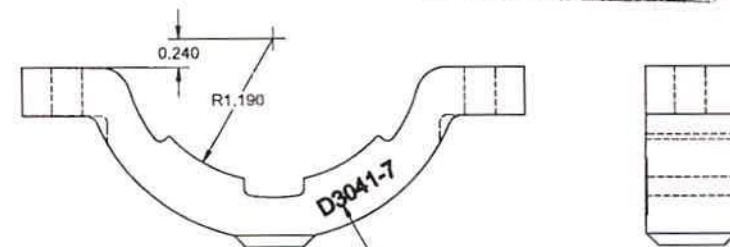
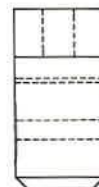
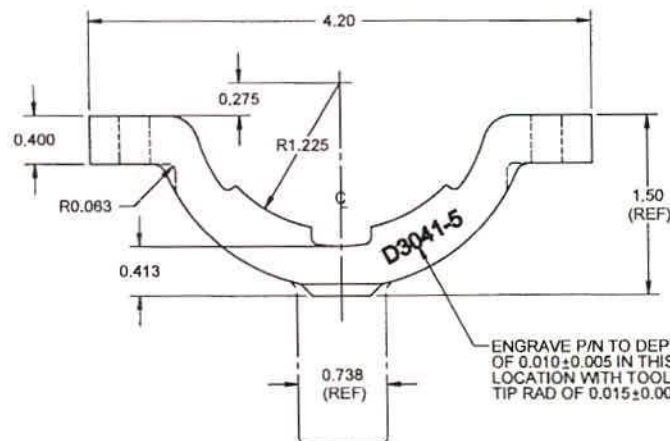
- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) STAKE D2611 BEARING AFTER POWDER COAT
 - 7) PART IS SYMMETRIC ABOUT C

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5J-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. D SHEET 1 OF 2
		SCALE 1:1

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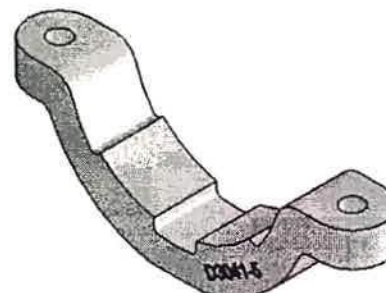
RELEASED

06.11.17



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

D3041-5 CLAMP



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT ϕ

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
901	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
B	H	D3041	SHEET 2 OF 2
DATE	TITLE	SCALE	
06.10.18	CLAMP	1:1	

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

43

D3041-3

Lug B30890

3287

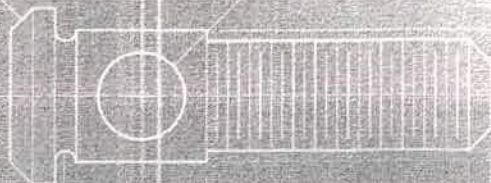
MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, April 2, 2007





20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **15824**
Date: Apr 02, 2007
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 03287	Sold By:
Shipped By: our truck	Ship Date: Apr 02, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-3 Clamp B30890 Material supplied by DART D2423 B30062 Short-shipped due to scarpped pieces: material supplied incorrectly cut. <i>EPot/04/02</i>	Each	45	43 <i>[Signature]</i>	2
Received by <i>[Signature]</i>	Thank you for your order!			